



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5635-041BENT
Job Sheet 197995



Part No: D5635-041BENT

Job Qty: 4 pcs

Part Name: Standard Skidtube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/19/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/9/19

Description:

Type: Stock

Note: DWG D5635 REV.A IPP REV:A 19.06.14 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	4 pcs	8/9/19	8/9/19	0.50	0.89	Skidtubes - Bend		mbc
120	QC 5	4 pcs	8/9/19	8/9/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	4 pcs	8/9/19	8/9/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		



Container No: S202982



Part: D5635 - 041BENT

Job No: 197995

Serial No/Batch: S202982

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/08/19

Plex 7/19/19 11:38 AM Dart.lajeunesse.marie

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BE
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	BAG 21 9-88
140	QC 21 - SA	4 pcs	8/9/19	0.00 0.00	
				QC 21 - SA - 21	
				QC 21 - SA - 70	

SEP 05 2019

Part Op 110 - ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- Bend FWD end of tube using bend prog
 Descriptions: D56345FWD and folio as per dwg D5635, cut fwd end of tube with saw table setup D5634 . 2- Test fit FWD cap.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: LG002 LOCATION : LG002

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-1-160	Extrusion Round 3" 206	4 pcs (1 ea)	110-Skidtubes - Bend - 1	S/68 238

Job Allocations

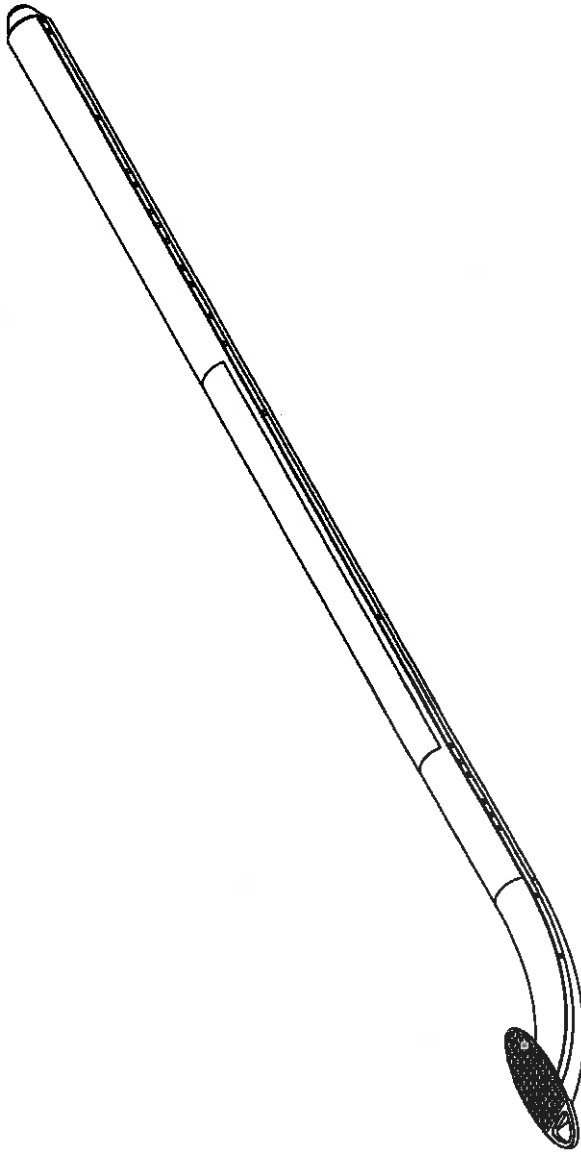
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2600-1-160	4	45	0

Part Specifications

Specifications could not be found.

Plex 7/19/19 11:38 AM Dart.lajeunesse.marie

QTY	P/N	DESCRIPTION
X	D5635-041	STANDARD SKIDTUBE
1	D2646	AFT CAP
21	D4720-1	SPACER
1	D5633-1	TOW STEP
1	D5635-1	SKIDTUBE
1	D5637-1	WEB
2	M52483-C272	SCREW, CSK 100"



D5635-041 SKIDTUBE ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "BLACK GLOSS" (4.3.5.13) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.4 ON INNER TUBE SURFACE AT AFT END.
 - 7) WEIGHT: 12.33 lb
 - 8) SEAL FASTENERS SURFACES WITH SIKAFLEX -241/-291 OR PROSEAL PS 880/1422 OR MIL-S-8802 CLASS B2 SEALANT
 - 9) INSTALL FASTENERS WET WITH SIKAFLEX -241/-291 OR PROSEAL PS 880/1422 OR MIL-S-8802 CLASS B2 SEALANT
 - 10) INSTALL WEB INTO OUTER TUBE WITH SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015.
 - 11) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5" ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.160" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE
WELDING PER DART QSI 004.
 - 12) IT IS PERMISSIBLE TO GRIND SKIDTUBE END TO IMPROVE FIT WITH TOW STEP. DIMENSIONS SHOWN AFTER GRINDING FOR TOW STEP.
 - 14) SLOT FOR D5633-1 TOW STEP THRU BACK WALL ONLY.

RELEASED
2019 JUN 27
EVAL 14-746

A	NEW ISSUE	DESCRIPTION	ZF	SY	DATE
REV.					
DESIGN	ZF				
DRAWN	ZF				
CHECKED	MW				
MFG. APPR.	DD				
APPROVED	NO				
DE APPR.	CP				
DATE	18.06.07				
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
DRAWING NO. D5635					
SHEET 1 OF 4					
TITLE STANDARD SKIDTUBE					
SCALE NTS					
COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED NOT TO BE USED FOR ANY PURPOSE OR COMING OR CONSIDERED TO BE UNCLASSIFIED					

APPROVED

Entered: _____ Date: _____

NCR No. _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				
Date: _____	Sequence #: _____	QTY Affected: _____	Disposition		MRB (QS1042)			
Description Work Order Deviation			Completed By			QC / QA Coordinator		
						Lead hand / Supervisor		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
Other/Details:								